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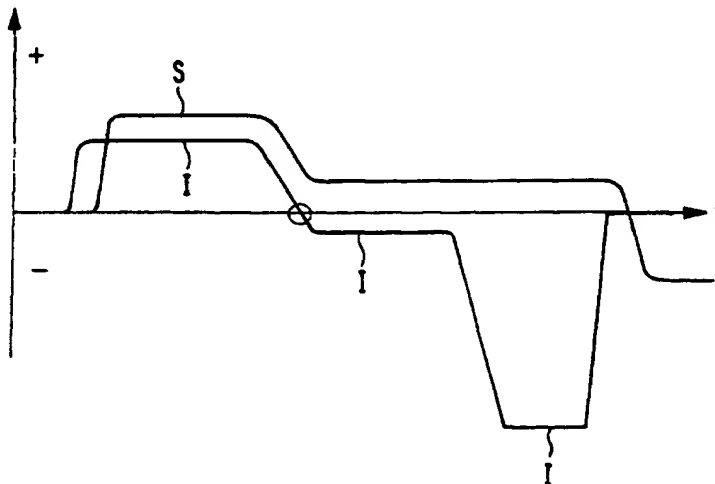
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(54) Title: **LIFT-AND-STRIKE WELDING PROCESS WITH CLEANING STAGE**



(57) Abstract: The present invention relates to a lift-and-strike welding process. In a first step, e.g. an aluminium surface (5) of a component is cleaned by striking an arc and then the element (4) to be connected is welded on by means of at least one second voltage. Besides a lift-and-strike welding apparatus, a further lift-and-strike welding process is also provided, wherein an electric cleaning current flows between a surface (5) of a component and an element to be welded thereon, in that the component rests on the surface (5) and then the element (4) is lifted off the surface (5) up to an approximately, in terms of time, constant distance for removing a coating from the surface (5) by means of an arc, then the current changes its polarity, wherein afterwards at least one welding current is produced and then the element (4) is welded to the surface (5).

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